



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3282-041
Job Sheet 195728



Part No: D3282-041

Job Qty: 10 pcs

Part Name: Float Web (206L/407)



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/30/19

Job Tracking No:

Due Date: 7/5/19

Created By: Kimberley Guerin

Type: Stock

Description:

Note: DWG REV D IPP Rev:B 05.09.23 Procedure change KJ/JLM IPP REV:C 11.09.20 remove LPS as per dwg revD DD verf:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Skidtubes - 1	10 pcs	7/5/19		0.00	1.67	Skidtubes - 1		20
							Skidtubes - 2		
							Skidtubes - 3		
							Skidtubes - 4		
							Skidtubes - 5		
							Skidtubes - 6		
							Skidtubes - 7		
110	HAAS 4 Axis - B4B	10 pcs	7/5/19		0.31	16.39	HAAS - 1 - B4B		111 2019/07/08
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
130	QC 8	10 pcs	7/5/19		0.00	0.00	QC 8 - 12		19/07/10
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		

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5/30/2019

[Dart Hawkesbury] Job Sheet - Guerin, Kimberley

					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
					QC 8 - 52	
					QC 8 - 23	
					QC 8 - 57	
140	Handfinish - 1-1 Chemical-B4B	10 pcs	7/5/19	0.00 2.33	Handfinish - 1 - 1 - B4B	
					Handfinish - 1 - 2 - B4B	
					Handfinish - 1 - 3 - B4B	
					Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
150	QC 7	10 pcs	7/5/19	0.00 0.00	QC 7 - 10	
					QC 7 - 13	
					QC 7 - 14	
					QC 7 - 15	
					QC 7 - 17	
					QC 7 - 18	
					QC 7 - 19	
					QC 7 - 2	
					QC 7 - 28	
					QC 7 - 3	
					QC 7 - 30	
					QC 7 - 34	
					QC 7 - 36	
					QC 7 - 37	
					QC 7 - 41	
					QC 7 - 47	
					QC 7 - 48	
					QC 7 - 51	
					QC 7 - 58	
					QC 7 - 59	

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						QC 7 - 60	MGC
						QC 7 - 9	
						QC 7 - 68	
						QC 7 - 50	
						QC 7 - 67	
						QC 7 - 40	
						QC 7 - 24	
						QC 7 - 43	
160 Skidtubes - 2 - B4B	10 pcs	7/5/19	0.00	2.50		Skidtubes - 1 - B4B	DD
						Skidtubes - 2 - B4B	
						Skidtubes - 3 - B4B	
						Skidtubes - 4 - B4B	
						Skidtubes - 5 - B4B	
						Skidtubes - 6 - B4B	
						Skidtubes - 7 - B4B	
170 QC 5	10 pcs	7/5/19	0.00	0.00		QC 5 - 10	BE
						QC 5 - 12	
						QC 5 - 17	
						QC 5 - 18	
						QC 5 - 19	
						QC 5 - 22	
						QC 5 - 24	
						QC 5 - 3	
						QC 5 - 43	
						QC 5 - 49	
						QC 5 - 51	
						QC 5 - 58	
						QC 5 - 68	
						QC 5 - 9	
						QC 5 - 50	
						QC 5 - 30	
						QC 5 - 40	
180 Packaging 3-1 - Stock - B4B	10 pcs	7/5/19	0.00	0.00		Packaging 3 - 1 - B4B	DD
						Packaging 3 - 2 - B4B	
						Packaging 3 - 3 - B4B	
						Packaging 3 - 4 - B4B	
						Packaging 3 - 5 - B4B	
						Packaging 3 - 6 - B4B	
						Packaging 3 - 7 - B4B	
						Packaging 3 - 8 - B4B	
						Packaging 3 - 9 - B4B	
						Packaging 3 - 10 - B4B	
						Packaging 3 - 11 - B4B	
						Packaging 3 - 12 - B4B	
						Packaging 3 - 13 - B4B	
						Packaging 3 - 14 - B4B	
						Packaging 3 - 15 - B4B	
						Packaging 3 - 16 - B4B	
						Packaging 3 - 17 - B4B	
						Packaging 3 - 18 - B4B	
						Packaging 3 - 19 - B4B	
						Packaging 3 - 20 - B4B	
						Packaging 3 - 21 - B4B	
						Packaging 3 - 22 - B4B	
						Packaging 3 - 23 - B4B	
						Packaging 3 - 24 - B4B	
						Packaging 3 - 25 - B4B	
						Packaging 3 - 26 - B4B	
						Packaging 3 - 27 - B4B	

				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
190 QC 21 - SA	10 pcs	7/5/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	JUL 12 2019
				QC 21 - SA - 53	

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Part Op 100 - (Skidtubes) 1-Cut to length as per Dwg D3282. 2- inspect for surface damage as per QSI0018
 Descriptions: 110 - (HAAS CNC Vertical Machine) 1-Machine as per Folio FA579 & Dwg D3282 2-Debur
 130 - (QC8- Inspect parts - second check)
 140 - (Chemical Conversion Coat per QSI005 4.1)
 150 - (QC7-Inspect Chemical Conversion Coat)
 160 - (Skidtubes) 1-Install doublers as per Dwg D3282.
 170 - (QC5- Inspect part completeness to step on W/O)
 180 - (Identify as per dwg & Stock Location: _____) LOCATION : LG002
 190 - (QC21- Final Inspection - Work Order Release)

Job BOM

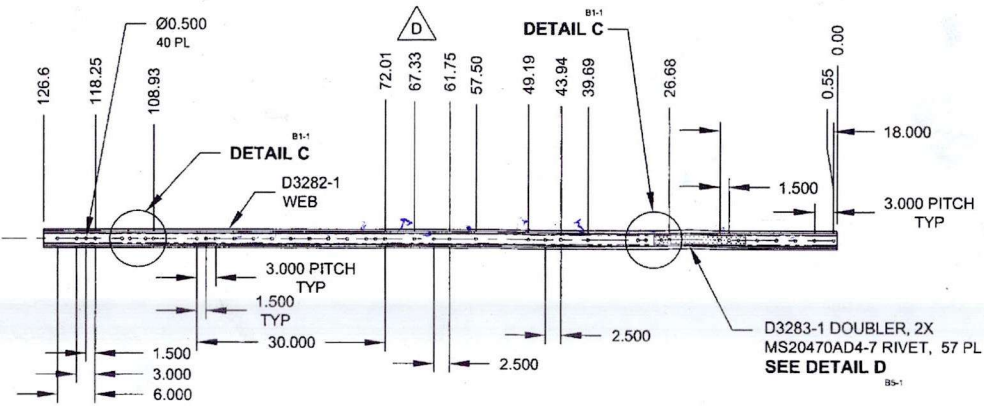
Part / Item	Component Name	Quantity	Operation	Container
D2792-130	Extrusion	10 pcs (1 ea)	100-Skidtubes - 1	B112 21x2 B5458
D3283-1	Doubler	20 pcs (2 ea)	160-Skidtubes - 2 - B4B	B126 28x3 S09054
MS20470AD4-7	Rivet, Universal Head	570 Ea (57 ea)	160-Skidtubes - 2 - B4B	S 126625 x192
				S102258x7 S 126625x378380

Job Allocations

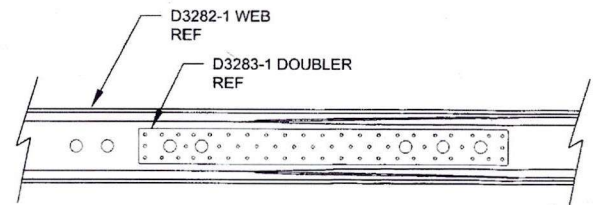
Operation	Component Part	Required	Inventory	Allocated
100-Skidtubes - 1	D2792-130	10	44	0
160-Skidtubes - 2 - B4B	D3283-1	20	26	0
	MS20470AD4-7	570	2,349	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Float Web	126.600inches $\pm$ 0.010	126.610 126.590		
2	Float Web	1.500inches $\pm$ 0.010	1.510 1.490		
3	Float Web	3.000inches $\pm$ 0.010	3.010 2.990		
4	Float Web	6.000inches $\pm$ 0.010	6.010 5.990		
5	Float Web	1.250inches $\pm$ 0.010	1.260 1.240		
6	Float Web	30.000inches $\pm$ 0.010	30.010 29.990		
7	Float Web	1.500inches $\pm$ 0.010	1.510 1.490		
8	Float Web	72.010inches $\pm$ 0.030	72.040 71.980		
9	Float Web	61.750inches $\pm$ 0.030	61.780 61.720		
10	Float Web	57.500inches $\pm$ 0.030	57.530 57.470		
11	Float Web	49.190inches $\pm$ 0.030	49.220 49.160		
12	Float Web	43.940inches $\pm$ 0.030	43.970 43.910		
13	Float Web	39.690inches $\pm$ 0.030	39.720 39.660		
14	Float Web	26.680inches $\pm$ 0.030	26.710 26.650		
15	Float Web	0.550inches $\pm$ 0.030	0.580 0.520		
16	Float Web	1.970inches $\pm$ 0.010	1.980 1.960		
17	Float Web	2.380inches $\pm$ 0.030	2.410 2.350		
18	Float Web	0.050inches $\pm$ 0.030	0.080 0.020		

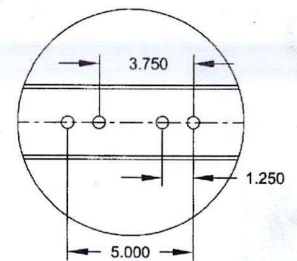
Plex 5/30/19 9:18 AM Dart.Guerin.Kimberley



D3282-041 WEB



DETAIL D
C4-1



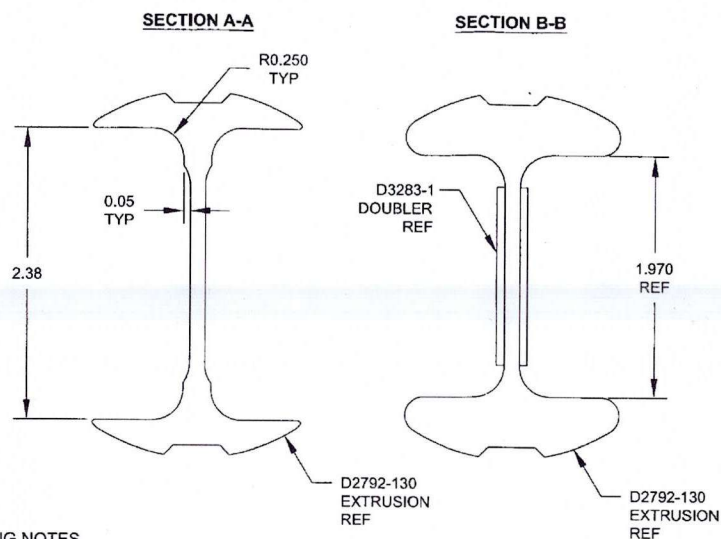
DETAIL C
DS-1 DS-1

NOTE: RIVET HOLES/DOUBLER NOT SHOWN FOR CLARITY

RELEASED
2011-09-12

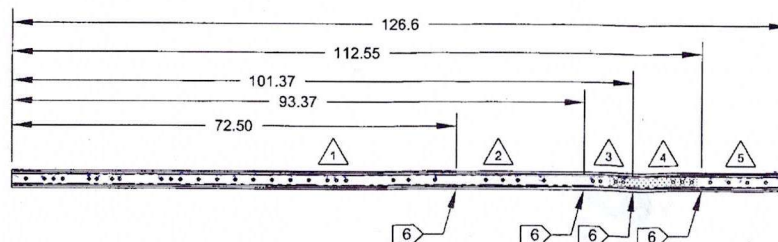
- NOTES:**
- 1) MAKE D3282-1 WEB FROM D2792-130 EXTRUSION
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK ALL SHARP EDGES 0.010 TO 0.020
 - 6) IDENTIFICATION: IDENTIFY WITH P/N "D3282-041" PER QSI 044 6.1 (FINE POINT PERMANENT INK MARKER)
 - 7) WEIGHT: 20.0 lbs
 - 8) SEE PAGE 2 FOR MACHINING DETAILS

D	ADD ADDITIONAL HOLE (ZN D6-1); REMOVE LPS-3 (ZN C3-1)	SC	11.05.05
C	REMOVE D3390-1, NOW MACHINED	CP	05.08.09
B	MOVE HOLES, ADD D3390-1 DOUBLERS	CP	05.03.16
A	NEW ISSUE	CP	04.05.05
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	DART AEROSPACE USA, INC PORT HADLOCK, WA	
DRAWN	SC		
CHECKED	JP	DRAWING NO.	REV. D
MFG. APPR.	JP	D3282	SHEET 1 OF 2
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	WEB	NTS
DATE	11.05.05	COPYRIGHT © 2004 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED IN THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



D3282-1 MACHINING NOTES

- 1 UNIFORM SECTION A-A
- 2 UNIFORM TAPER FROM SECTION A-A TO SECTION B-B
- 3 UNIFORM SECTION B-B
- 4 UNIFORM TAPER FROM SECTION B-B TO SECTION A-A
- 5 DRILL #30 (Ø0.128 REF) HOLES (57 PLACES) TO LINE UP WITH D3283-1, SEE DETAIL D FOR REFERENCE
- 6 UNIFORM SECTION A-A
- 7 R1.00 BETWEEN SECTIONS



RELEASED
2011-09-12
JP

DESIGN	CP	DART AEROSPACE USA, INC	
DRAWN	SC	PORT HADLOCK, WA	
CHECKED	GP	DRAWING NO.	REV. D
MFG. APPR.	EE	D3282	SHEET 2 OF 2
APPROVED	JP	TITLE	SCALE
DE APPR.		WEB	NTS
DATE	11.05.05	COPYRIGHT © 2004 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR FOR ANY COMMUNICATIONS TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

DART AEROSPACE LTD		Work Order:	
Description: Float Web		Part Number:	D3282-041
Inspection Dwg: D3282	Rev: D	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
126.6	+/-0.100	126.625	✓		tape	
1.500	+/-0.010	1.246496	✓		vernier	
3.000	+/-0.010	2.994	✓		vernier	
6.000	+/-0.010	5.995	✓		vernier	
1.250	+/-0.010	1.246	✓		vernier	
30.000	+/-0.010	29.996	✓		tape	
1.500	+/-0.010	1.497	✓		vernier	
72.01	+/-0.030	72.00	✓		tape	
61.75	+/-0.030	61.750	✓		tape	
57.50	+/-0.030	57.500	✓		tape	
49.19	+/-0.030	49.187	✓		tape	
43.94	+/-0.030	43.950	✓		tape	
39.69	+/-0.030	39.700	✓		tape	
26.68	+/-0.030	26.675	✓		tape	
0.55	+/-0.030	.550	✓		vernier	
1.970	+/-0.010	1.970	✓		vernier	
2.38	+/-0.030	2.375	✓		vernier	
0.05	+/-0.030	.058	✓		vernier / feeler	

Measured by: <i>mm</i>	Audited by: <i>mm L</i>	Preliminary Approval:
Date: 2019/07/08	Date: 19/07/10	Date:

Rev	Date	Change	Revised by	Approved
A	07.04.02	New Issue	KJ/JLM	
B	12.02.01	Dwg Rev updated	KJ	